

## 546 | 100

### Combined Surface Planing and Thicknessing Machine



#### Technical Specifications

Planing Width:	630 mm
Planing height:	3 - 250 mm
Table Length of Surface Planer:	2555 mm
Table Length of Thicknesser:	1100 + 400 mm
Machine Height:	912 mm
Chip Removal of Surface Planer:	max. 5 mm
Chip Removal of Thicknesser:	max. 8 mm
Cutter Block:	Ø 125 mm   Speed 5000 rpm
Main Motor Power:	7.5 kW (10 HP)
Feed Motor Power:	0.55 kW (0.8 HP) / 0.75 kW (1.0 HP)
Feed rate:	7 + 14 m/min (standard)   3 - 24 m/min (Option "variable")
Protection Class:	IP54
Dimensions:	refer to ⇒ page 2
Net Weight:	approx. 1210 kg
Ground load:	4.0 kg/cm <sup>2</sup>
Voltage:	400 V / 50 Hz
Supply Cable:	Cu, 5-wire The cross-section must be determined on site by a qualified electrician!
Connecting Phases:	L1   L2   L3   N   PE
Fuse Protection:	32 A or 35 A
Extraction Planer & Jointer:	Ø 160 mm, negative pressure 900 Pa
Extraction Thicknesser:	Ø 160 mm, negative pressure 550 Pa
Extraction Capacity:	approx. 1450 m <sup>3</sup> /h at 20 m/s (dry chips)
Signal Generator Lines for Extraction Unit:	Terminal 03 + 04 on contactor K2 (see circuit diagram)



- Caution: The regulations of the local EVU apply.
- Checking the impedance of the fault loop and the suitability of the overcurrent protection devices must be carried out at the installation site of the machine.
- The electrical connection may only be carried out by an authorised electrician.
- With the variable feed rate option, the N conductor must also be connected to the main switch (note: "N" is loaded).
- The circuit diagram can be found in the control cabinet.

#### Emission Values according to EN 860 <sup>1</sup>

(when using the standard cutter block)

Workplace-related noise emission levels in dB(A):	Surface planing: 83 (idle)   88 (machining) Thicknessing: <sup>A1</sup> 86 / <sup>A2</sup> 84 (Idle)   <sup>A1</sup> 87 / <sup>A2</sup> 85 (machining)
Sound power level in dB(A):	Surface planing: 102 (idle)   104 (machining) Thicknessing: 102 (idle)   101 (machining)
Workplace-related dust emission value <sup>2 3</sup> :	Surface planing: 0.43 mg/m <sup>3</sup> air Thicknessing: 1.72 mg/m <sup>3</sup> air

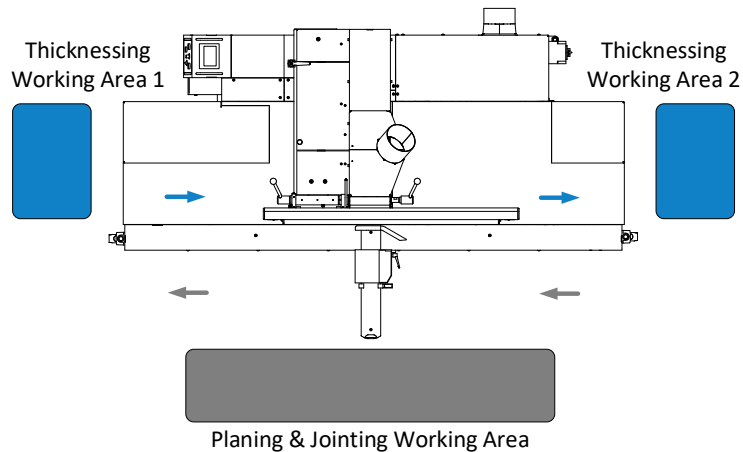


The noise emission values of the machine partly exceed 85 dB(A)!  
Therefore, suitable hearing protection must be provided to the personnel!

<sup>1</sup> Uncertainty allowance K = 4 dB(A) | <sup>2</sup> Permissible: 2.0 mg/m<sup>3</sup> air | <sup>3</sup> Dust emission values determined acc. to GS-HO-05

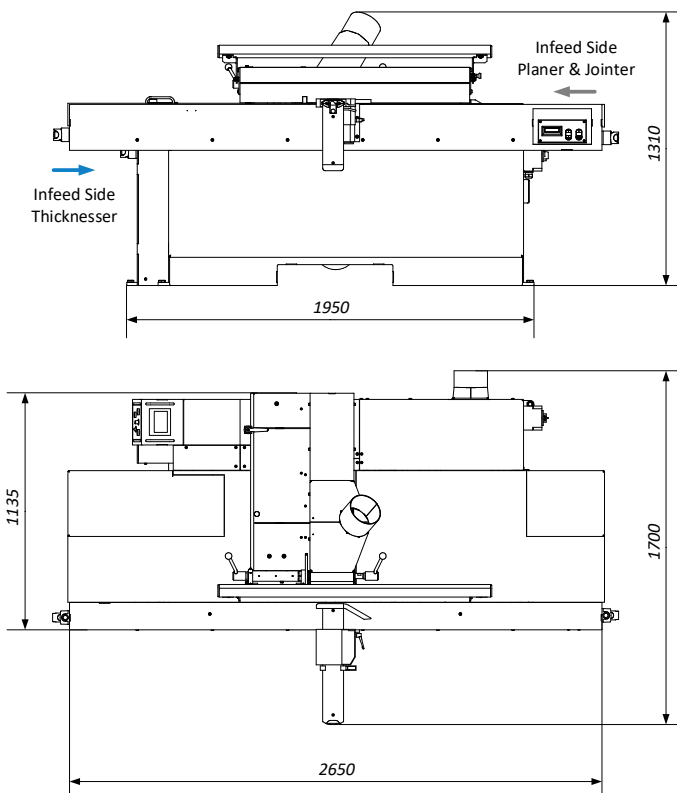
<sup>A1</sup> Working area 1 | <sup>A2</sup> Working area 2 (see ⇒ next page)

## Working Areas

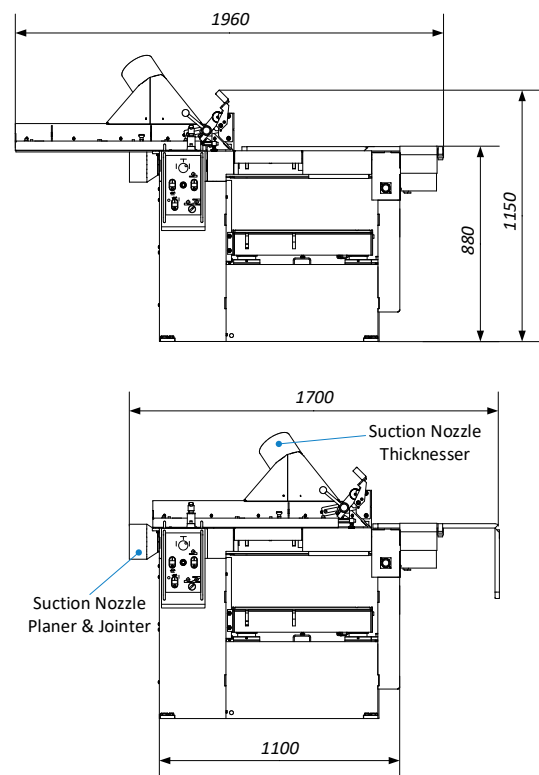


## Dimensions

Front and Top View:



Side View:



## Space Requirement:

The effective space requirement usually depends on the dimensions of the machine and the dimensions of the workpieces to be processed. In general, provide sufficient space around the machine and also calculate the required workplace for the operating, maintenance and auxiliary personnel as well as for the infeed and outfeed of the workpieces.

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